

# Work Order ID 57971

April 21, 2010 9:26:22 AM



Page 1

Item ID: D4038-7

Revision ID:

Item Name: Block

Start Date: 23/04/2010 Start Qty: 4.00

Required Date: 30/04/2010 Req'd Qty: 4.00

Reference:

Approvals: Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start

Stop

Sequence ID/  
Work Center ID      Operation  
Description

Draw Nbr	Revision Nbr
D4038	B

Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

0.00

0.00

0.00

0.00

100



Bandsaw

Jeaspa Bandsaw

Memo

CUT BLANK 2.125" LONG

105



HAAS 1

HAAS CNC vertical machine #1

Memo

Mill as per Dwg and Folio FA884

DWG REV: B

FOLIO REV: AK

DEBURR

*and 10/04/24*

*and 10/04/25*

4

4

Ø

Ø

# Work Order ID 57971

April 21, 2010 9:26:22 AM



Page 2

Item ID: D4038-7

Accept



Setup Start



Revision ID:

Stop



Item Name: Block

Start Date: 23/04/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 30/04/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

*ant 10/04/25*

*4 0*

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

*B.A 10/04/26*

*4 0*

130

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

*H BK 10-4-26.*

# Work Order ID 57971

April 21, 2010 9:26:22 AM



Page 3

Item ID: D4038-7

Accept



Setup Start



Revision ID:

Stop



Item Name: Block

Start Date: 23/04/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 30/04/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

*M 10/04/26*

4

Ø

160

Identify as per dwg & Stock Location:

*ST 110*

0.00



Packaging

Memo

0.00

Packaging

*M-H 10/04/26*

*(LX)*

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*10/04/27 ME 10-4-26*

# Picklist Print

April 21, 2010 9:26:21 AM

Page 1

Work Order ID: 57971

Parent Item: D4038-7

Parent Item Name: Block

Comments: Ipp Rev:A New Issue 09-12-14 JLM Verified By:EC

Start Date: 23/04/2010

Required Date: 30/04/2010

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B1.500X02.00 0		Purchased	No				f	9.5000	0.6989			



6061-T6 Bar 1.50 x 2.00



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT10

110167

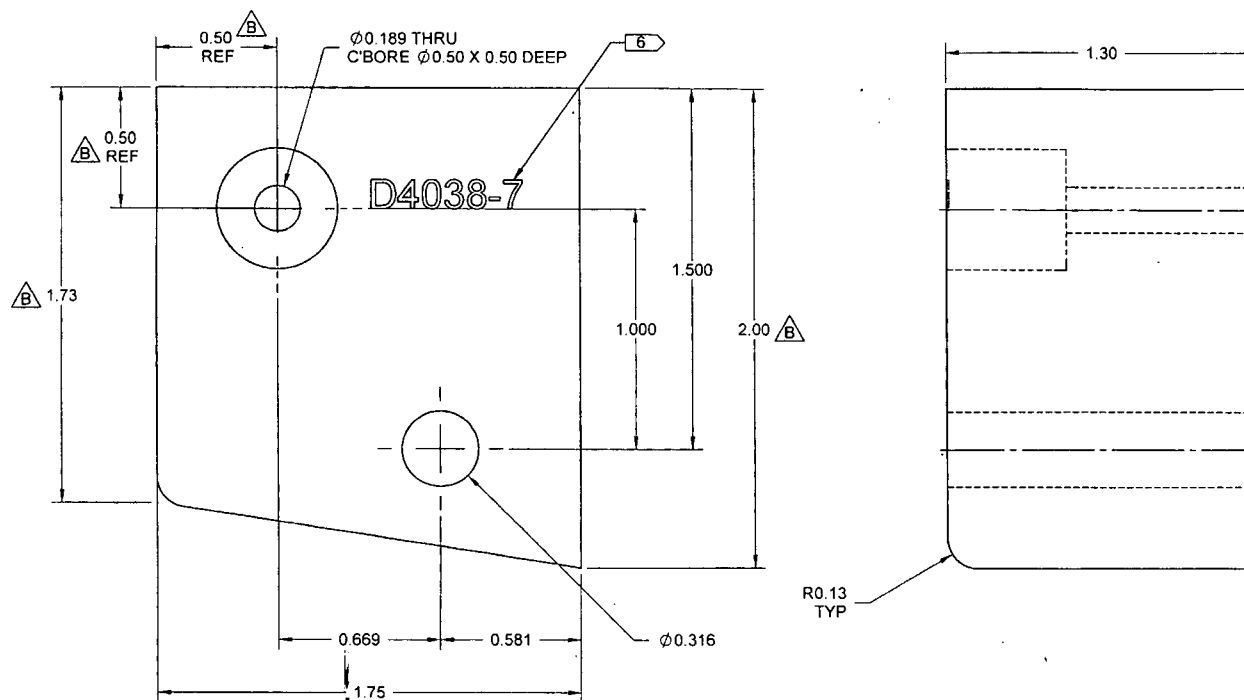
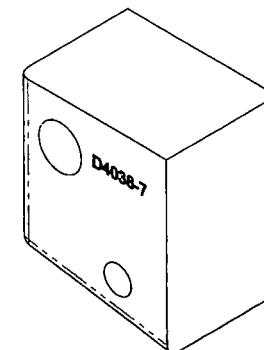
9.5

9.5

.6989 ml 10/04/24



w/o 57971



D4038-7 BLOCK

RELEASED  
2010-04-14  
MD

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
REF DART SPEC M6061T68
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N IN THIS AREA AS SHOWN TO MAX DEPTH  
OF 0.010 IN 0.12 HIGH LETTERS WITH MIN RADIUS TOOL OF 0.015
- 7) WEIGHT: 0.39 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4038	SHEET 9 OF 14
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
DATE	10.01.05	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	